RG104 E-1 Box 134 Apr-July 1885

Mint of the United States at Philadelphia, Pa.,

SUPERINTENDENT'S OFFICE.

A. Garrison & Co.
Pittsburg Pa

, 188 .

Gn.

As you have been furnishing the 10" chilled iron rolls used by the Mint for some years, I shall consider it a favor if you will allow me the use of your judgement as to the capacity of the same: In order therefor to give you an idea of what has been done, and what is proposed, I submit the following

These rolls are used for the purpose of breaking down, or reducing the standard ounce ingots, the measurements of the transverse section of the ingot being $1\frac{625}{1000}$" in width, by $\frac{46}{1000}$" in thickness,

The breaking down, or reduction in thickness prior to annealing is made in seven drafts with the following reduction in each,

Yrs

RG104 E-1 Box 134 Apr-July 1885

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, 188 .

Reduction	in	Thickness	on	1st	draft	=	$\frac{87}{1000}$ "
"	"	"	"	2nd	"	=	$\frac{47}{1000}$ "
"	"	"	"	3rd	"	=	$\frac{46}{1000}$ "
"	"	"	"	4th	"	=	$\frac{42}{1000}$ "
"	"	"	"	5th	"	=	$\frac{38}{1000}$ "
"	"	"	"	6th	"	=	$\frac{26}{1000}$ "
"	"	"	"	7th	"	=	$\frac{17}{1000}$ "
				Total reduction			$\frac{803}{1000}$ "

It occurred Recd desirable to facilitate the work by making the transverse Reclim of the right $3\frac{250}{1000}$" in width, by $\frac{46}{1000}$" in thickness, thereby following the same reductions as above with the enlarged right, would you consider it safe to make the experiment as far as the tensile strength of the rolls is concerned?

By referring to former drawings and gauges you will notice the dimensions of rolls, the distance between bearings &c.

RG104 E-1 Box 134 Apr-July 1885

Mint of the United States at Philadelphia, Pa.,

SUPERINTENDENT'S OFFICE,

July 8, 1885.

Samuel James
~~Superintendent.~~
Foreman Mach. Shop

Allen. Notice signed to proposed Strain upon Rolls, in Reducing Cents Dollar weight &c

RECEIVED JUL 9 1885 U. S. MINT, PHILA.

No. of Enclosures,

NARA RG104, Entry 1, Box 134

[Abstract:] Mem. with regard to proposal…

Mint of the United States at Philadelphia, Pa.,
Superintendent's Office,

A. Garrison & Co.
Pittsburgh, Pa.

~~Sir.~~

As you have been furnishing the 10" chilled iron rolls used by the Mint for some years, I shall consider it a favor if you will allow me the use of your judgement as to the capacity of the same: in order therefore to give you an idea of what has been done, and what is proposed, I submit the following.

These rollers are used for the purpose of breaking down, or reducing the standard dollar ingots, the measurements of the transverse section of the ingot being 1 625/1000 " in width, by 46/1000 " in thickness.

The breaking down, or reduction in thickness prior to annealing is made in seven drafts with the following reduction in each, viz

Reduction in thickness on	1st draft =	87/1000 "
" " " "	2nd " =	47/1000 "
" " " "	3rd " =	46/1000 "
" " " "	4th " =	42/1000 "
" " " "	5th " =	38/1000 "
" " " "	6th " =	26/1000 "
" " " "	7th " =	17/1000 "
	Total reduction	303/1000 "

It would seem desirable to facilitate the work by making the transverse section of the ingot 3 250/1000 " in width, by 46/1000 " in thickness, therefore following the same reductions as above with the enlarged ingot, would you consider it safe to make the experiment so far as the tensile strength of the molds is concerned?

By referring to former drawings and gauges you will notice the dimensions of rolls, the distance between bearing &.